



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5636-041
Job Sheet 197994



Part No: D5636-041

Job Qty: 1 pcs

Part Name: Float Web Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/19/19

Job Tracking No:

Due Date: 8/9/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D5636 REV.A IPP REV:A 19.01.15 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - 1	1 pcs	8/9/19		0.00	1.00	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
110	QC 5	1 pcs	8/9/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
120	Handfinish - 1-1 Chemical-B4B	1 pcs	8/9/19		0.00	0.20	QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
							Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		
							Handfinish - 1 - 5 - B4B		



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CANADA
TEL: 1 613 632-5200
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Container No: S213214



Part: D5636-041

Job No: 197994

Serial No/Batch: S213214

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/12/19

				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
130 QC 7	1 pcs	8/9/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
140 Skidtubes - 2 - B4B	1 pcs	8/9/19	0.00 0.50	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
150 QC 5	1 pcs	8/9/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	

				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
160	Packaging 3-1 - Stock - B4B	1	8/9/19	0.00 0.00	Packaging 3 - 1 - B4B
	pcs				Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
170	QC 21 - SA	1	8/9/19	0.00 0.00	QC 21 - SA - 21
	pcs				QC 21 - SA - 70

SEP 18 2019

Part Op 100 - 1- CUT WEB TO LENGHT AS PER DWG AND DEBURR. 2- DRILL HOLES IN D5636-1 AS PER DWG (USE DT10539) 3- USE CLECOS TO SECURE D5645-1 DOUBLER, TRANSFER DRILL HOLES IN WEB AS PER DWG 4- OPEN HOLES TO SIZE AS PER DWG , DEBURR.

110 - QC5- Inspect part completeness to step on W/O

120 - CHEMICAL CONVERSION COAT WEB AND DOUBLERS

130 - QC7-Inspect Chemical Conversion Coat

140 - INSTALL DOUBLERS AS PER DWG

150 - QC5- Inspect part completeness to step on W/O

160 - Identify as per dwg & Stock Location: **LG-002**
 170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-7-140	Extrusion I-Beam Thick	1 pcs (1 ea)	100-Skidtubes - 1	B162496
D5645-1	Doubler	2 pcs (2 ea)	100-Skidtubes - 1	S212301
MS20470AD4-7	Rivet, Universal Head	91 Ea (91 ea)	140-Skidtubes - 2 - B4B	S126675 S179669

x248
x25

Job Allocations

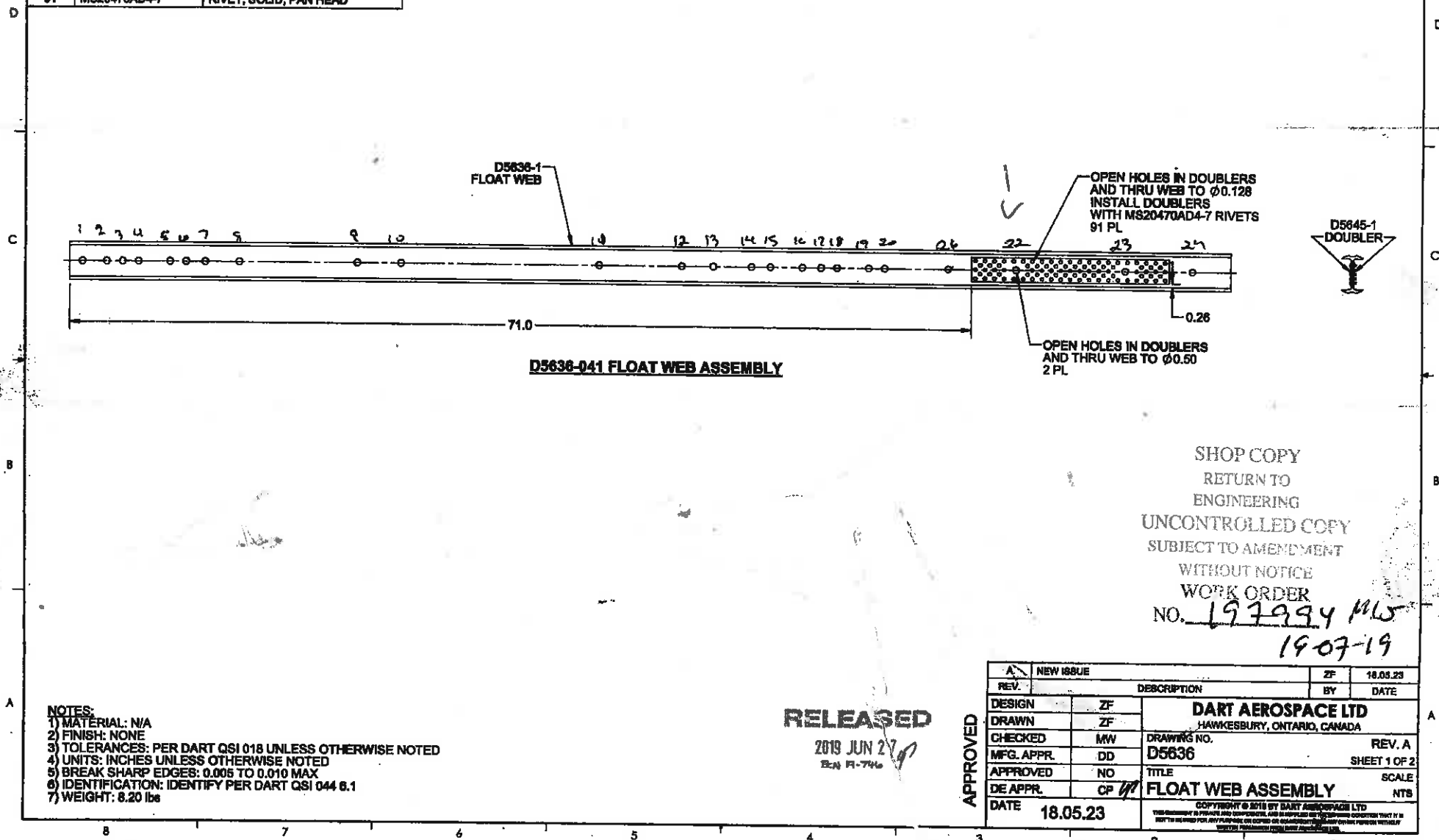
Operation	Component Part	Required	Inventory	Allocated
100-Skidtubes - 1	D2600-7-140	1	123	0
	D5645-1	2	0	0
140-Skidtubes - 2 - B4B	MS20470AD4-7	91	1,623	0

Part Specifications

Specifications could not be found.

Plex 7/19/19 11:37 AM Dart.lajeunesse.marie

QTY -041	P/N	DESCRIPTION
X	D5636-041	FLOAT WEB ASSEMBLY
1	D5636-1	FLOAT WEB
2	D5645-1	DOUBLER
91	MS20470AD4-7	RIVET, SOLID, PAN HEAD



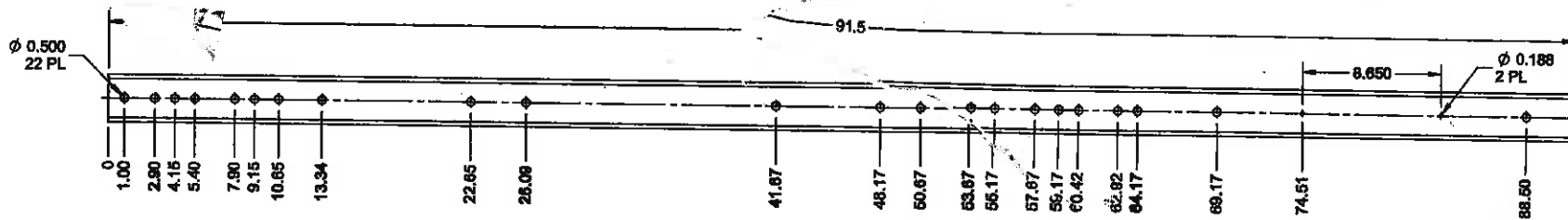
8 7 6 5 4 3 2 1

D

C

B

A



D5636-1 FLOAT WEB

RELEASED
2019 JUN 27

- NOTES:**
- 1) MATERIAL: MAKE FROM D2600-7 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
 - 7) WEIGHT: 7.75 lbs

APPROVED

DESIGN	ZF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. A
MFG. APPR.	DD	D5636	SHEET 2 OF 2
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	FLOAT WEB ASSEMBLY	NTS
DATE	18.05.23	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

DART AEROSPACE LTD		Work Order: 197994
Description: Float Web Assembly		Part Number: D5636-041
Inspection Dwg: 5636 Rev: A		DT 10539 Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	0.030	0.991			caliper	
2.90	0.030	2.889			caliper	
4.15	0.030	4.142			caliper	
5.40	0.030	5.399			caliper	
7.90	0.030	7.893			caliper	
9.15		10.643 9.144			caliper	
10.65		10.643			caliper	
13.34		13.329			TAPE	
22.65		22.635			TAPE	
26.09		26.078			TAPE	
41.67		41.657			TAPE	
48.17		48.162			TAPE	
50.67		50.662			TAPE	
53.67		53.657			TAPE	
55.17		55.163			TAPE	
57.67		57.663			TAPE	
59.17		59.163			TAPE	
60.42		60.413			TAPE	
62.92		62.913			TAPE	
64.17		64.162			TAPE	
69.17		69.162			TAPE	
74.51		74.444			TAPE	* WORK ORDER NCR
88.50	0.030	88.438			TAPE	* See NCR
8.650	0.010	8.644			caliper	

Measured by: MGG	Audited by: DD	Preliminary Approval:
Date: Sept 11 - 2019	Date: Sept 11 - 2019	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

A 10.04.15

Entered:

TR

Date:

Oct 21/19



NCR No.

19-7436

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

Job:

197994

Part No.

DS636-041

DISPOSITION

Rework ☒

Scrap ☐

Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐

Machining ☐

Large Fab ☐

Cross tube ☐

Small Fab ☐

Finishing ☐

Eng. (Non-AW) ☐

Prod. Eng. Coord. ☐

Rec/Store/Packaging ☐

Engineering ☒

Water Jet ☐

Supplier ☐

Quality ☐

Date:

19-09-05

Sequence #:

QTY Affected:

3

MRB (QSI042)

NO

19.09.05

Description Work Order Deviation

Disposition

3 aftmost holes at 74.51, 74.51+8.650,
88.50 per dwg do not align with
skid tube holes

Dwg error, place holes 74.45,
74.45+8.650, 88.44.
Next dwg rev will reflect
these dimensions

Completed By

TW
19-10-7

Lead hand / Supervisor

TW
19-10-7

QC / QA Coordinator

DAS
68
9-89

OCT 09 2019

Root Cause

Operator ☐

Manufacturing Process ☒

Equip/Tooling ☐

Handling/Preservation ☐

Material ☐

Product Improvement ☐

Process Improvement ☐

Human Factors ☐

FAULT CATEGORY

Pressure/Forced ☐

Bending ☐

Crushing ☐

Cracks ☐

Crimp/Kink/Ripple/Wave/Twist ☐

Marks/Chatter ☐

Mislabeled ☐

Contamination ☐

Misaligned/off center ☐

BOM/Route ☐

Broken/Damage/Defect ☐

Incomplete/Unclear Instructions ☐

Drill Holes ☐

Fit/Function ☐

Power Loss/Surge ☐

Folio/Program ☐

Grain Direction ☐

Weld ☐

Wrong Stock Pulled ☐

Out of Sequence ☐

Off-set/Set-up ☐

Positioned Wrong ☐

Outside Tolerance ☐

Drawing ☒

Finish ☐

Part Lost/Missing ☐

Misread ☐

Other/Details: